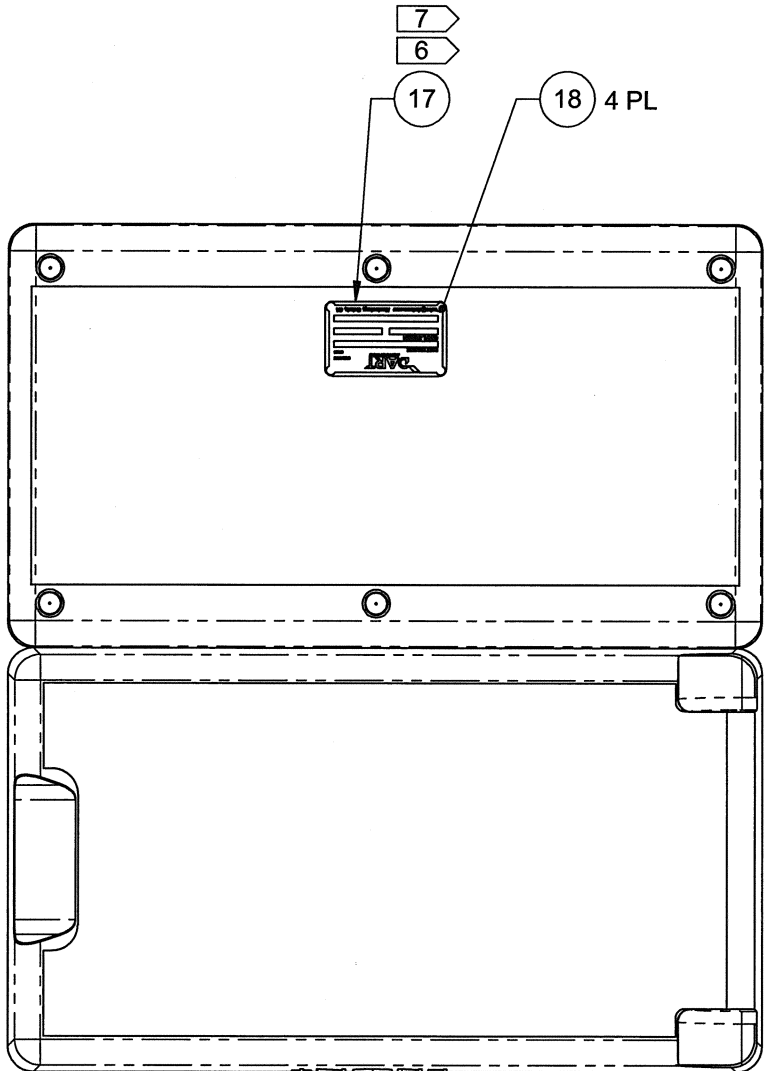
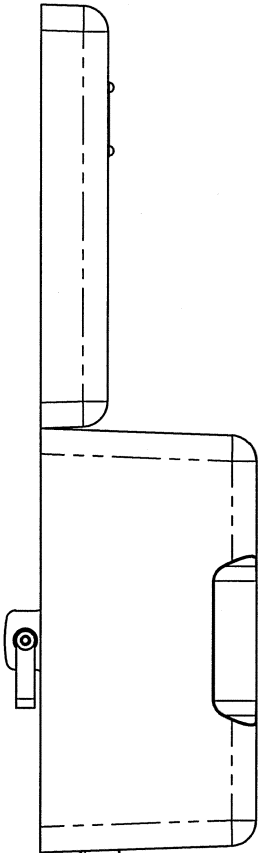
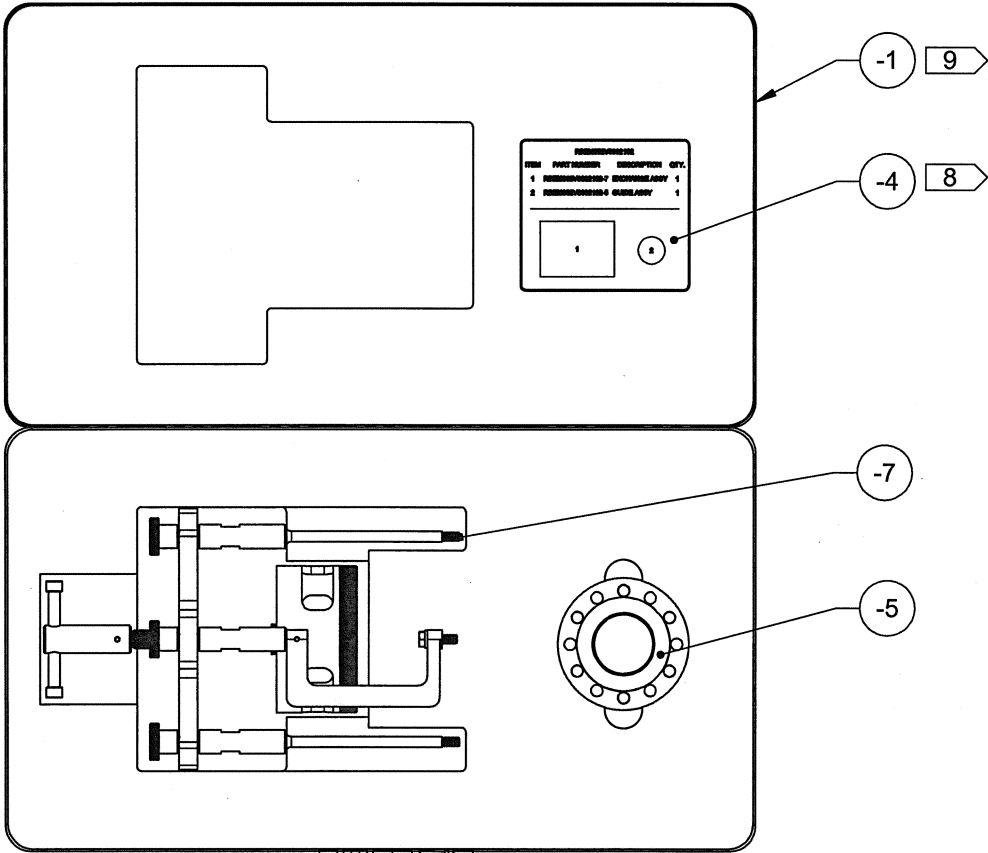


ITEM #	QTY	PART #	PART TITLE
-1	1	RBEM652V3002102-1	PACKAGING ASSY
-4	1	RBEM652V3002102-4	CONTENT PLACARD
-5	1	RBEM652V3002102-5	GUIDE ASSEMBLY
-7	1	RBEM652V3002102-7	EXCHANGE ASSEMBLY
17	1	RB41011	DART PLACARD
18	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.

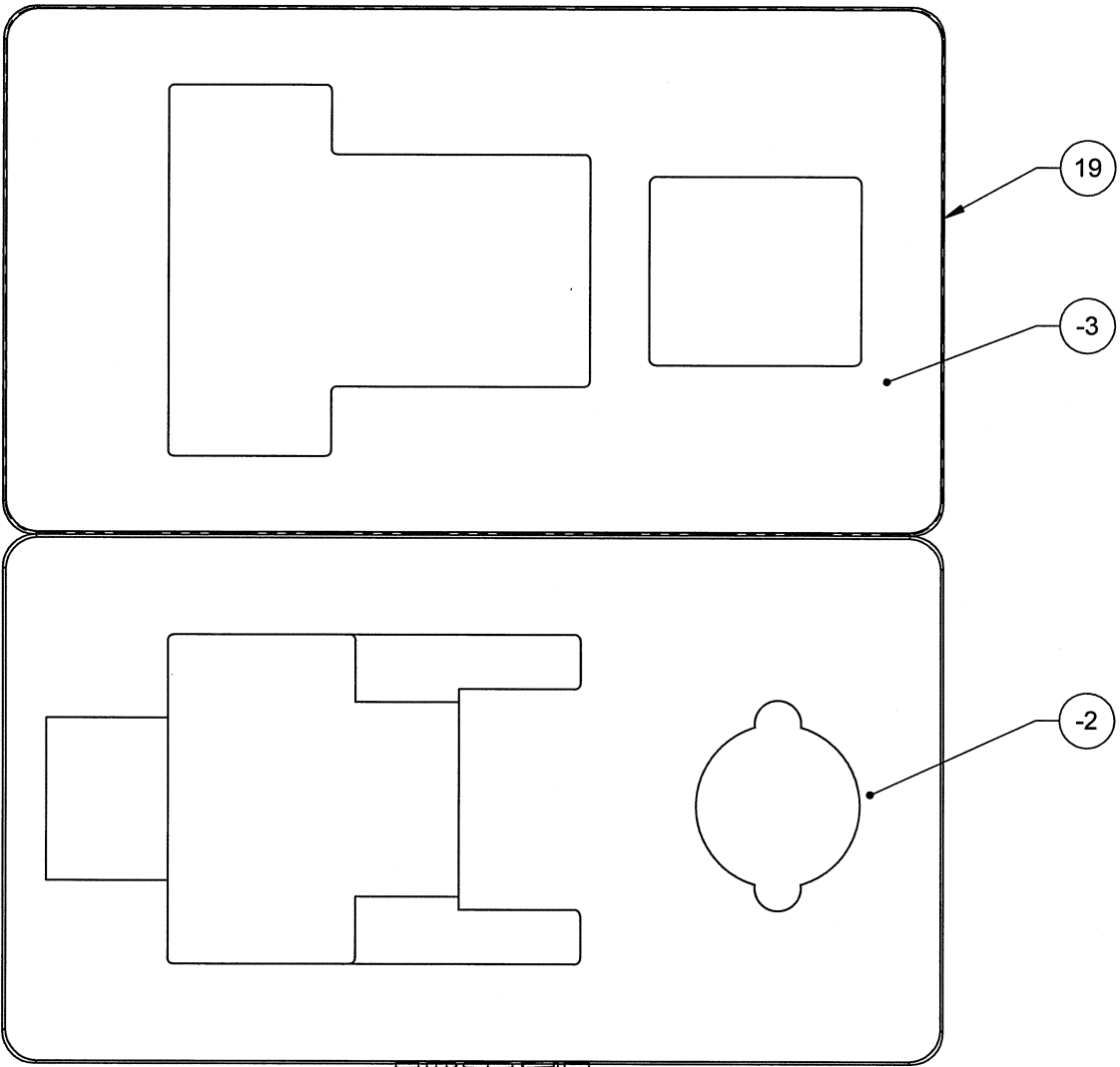


RBEM652V3002102 TAIL GEAR BOX INPUT SEAL EXCHANGE

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: ENGRAVE THE T/N ON THE DART PLACARD WHERE INDICATED
 - 7) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
 - 8) HOT GLUE THE CONTENT PLACARD ONTO THE TOP FOAM
 - 9) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

A	NEW ISSUE SUPERCEDES RBEM652V3002101-M	19-742	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 1 OF 17
APPROVED	WJP	TITLE	SCALE
DATE 2019-05-24		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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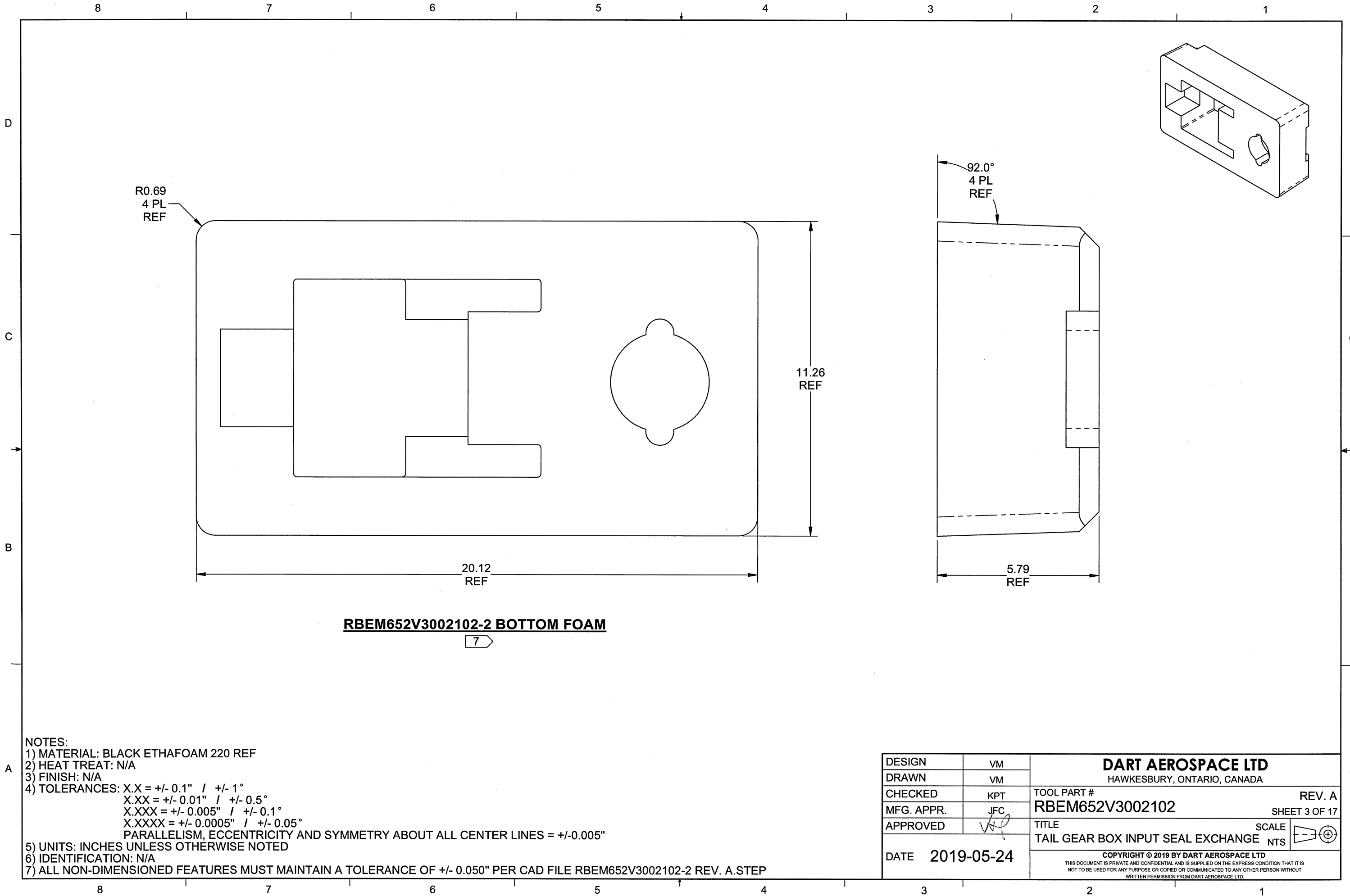
ITEM #	QTY	PART #	PART TITLE
-2	1	RBEM652V3002102-2	BOTTOM FOAM
-3	1	RBEM652V3002102-3	TOP FOAM
19	1	PELICAN #APP-1510-E	PELICAN CASE 1510



RBEM652V3002102-1 PACKAGING ASSY

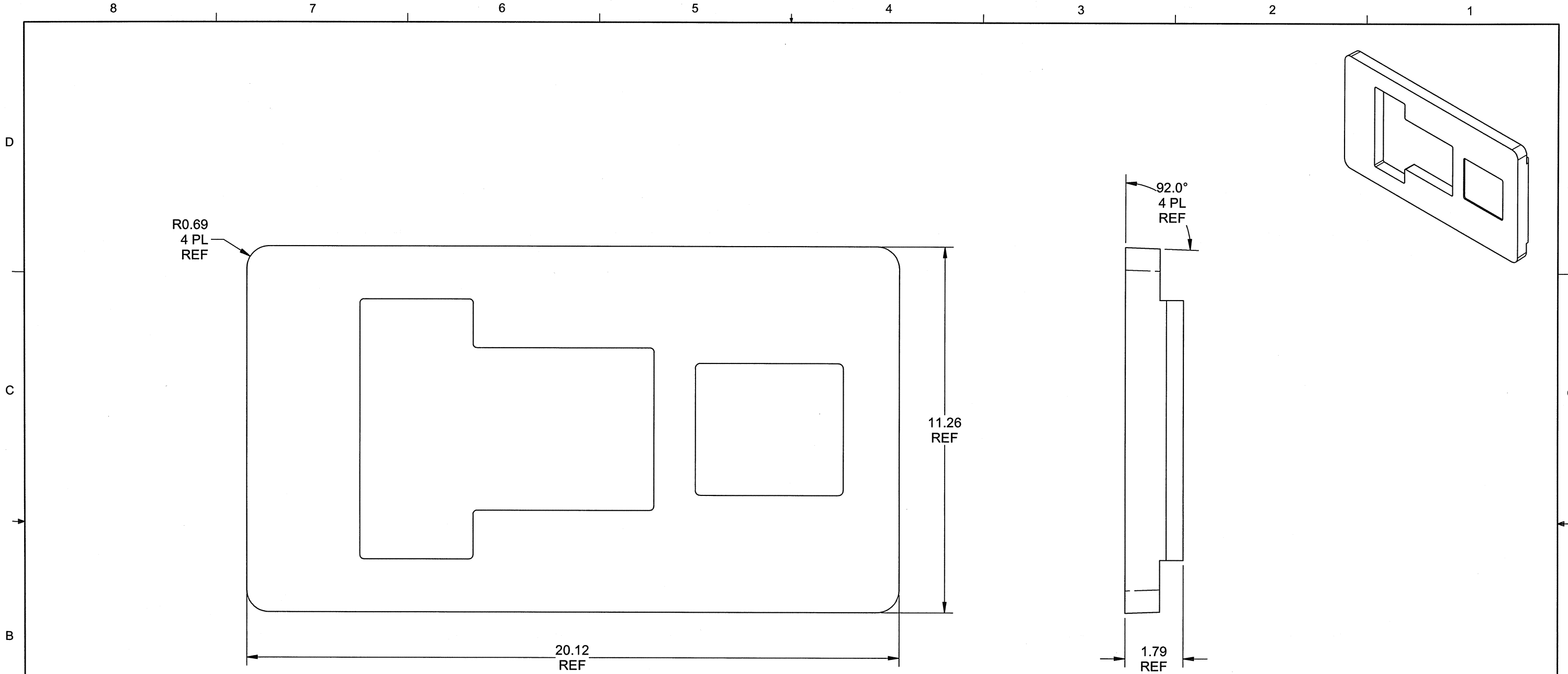
NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 2 OF 17
APPROVED		TITLE	SCALE
DATE 2019-05-24		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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NOTES:
1) MATERIAL: BLACK ETHAFOAM 220 REF
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBEM652V3002102-2 REV. A.STEP

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 3 OF 17
APPROVED		TITLE	SCALE
DATE 2019-05-24		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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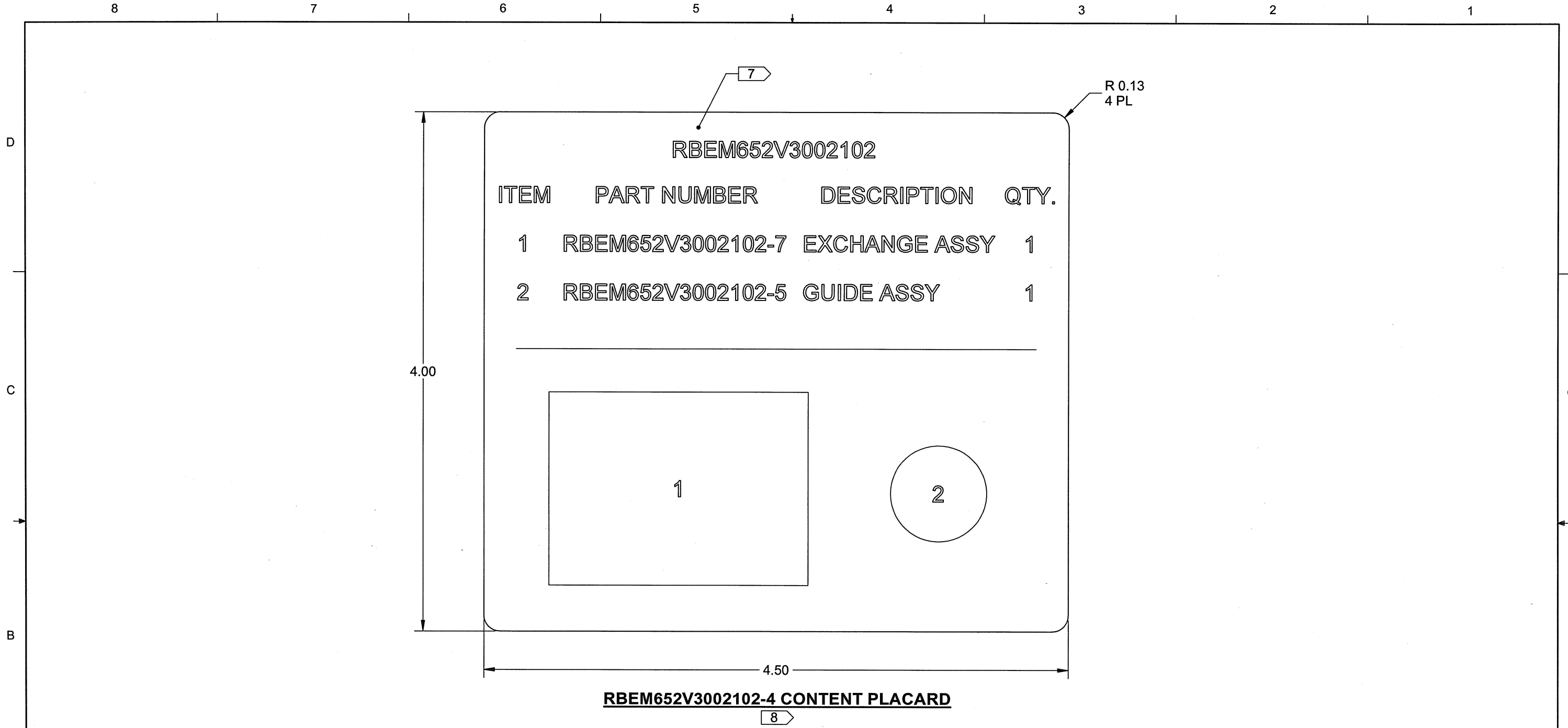


RBEM652V3002102-3 TOP FOAM

7

NOTES:
1) MATERIAL: BLACK ETHAFOAM 220 REF
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBEM652V3002102-3 REV. A.STEP

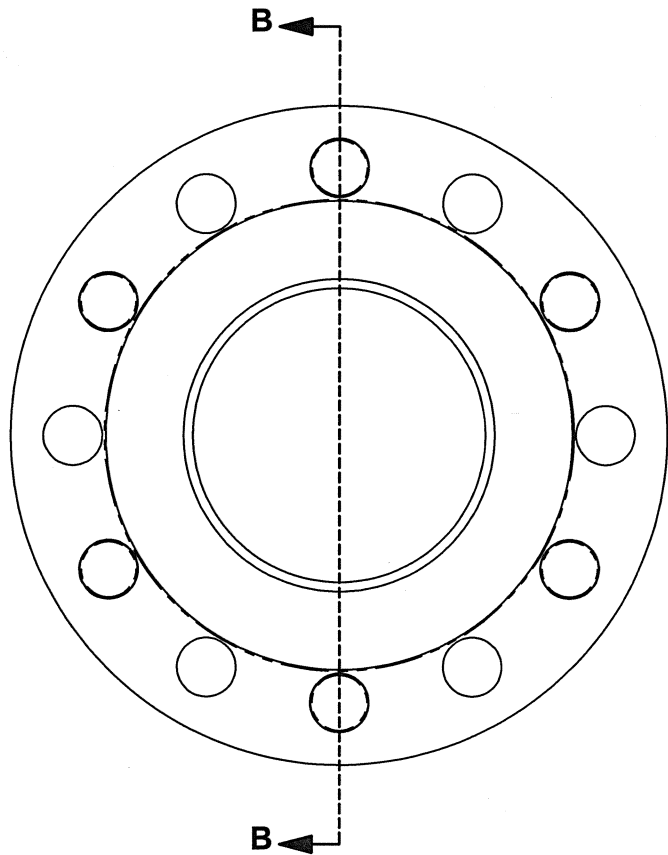
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DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 4 OF 17
APPROVED		TITLE	SCALE
DATE 2019-05-24		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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NOTES:
1) MATERIAL: JOHNSON PLASTICS #LM922402 OR EQUIV. (BLACK/WHITE MICROSURFACED IMPACT ACRYLIC 1/16" THK.)
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) BLACK BACKGROUND WITH WHITE LETTERS AND LINES
8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBEM652V3002102-4 REV. A.DXF

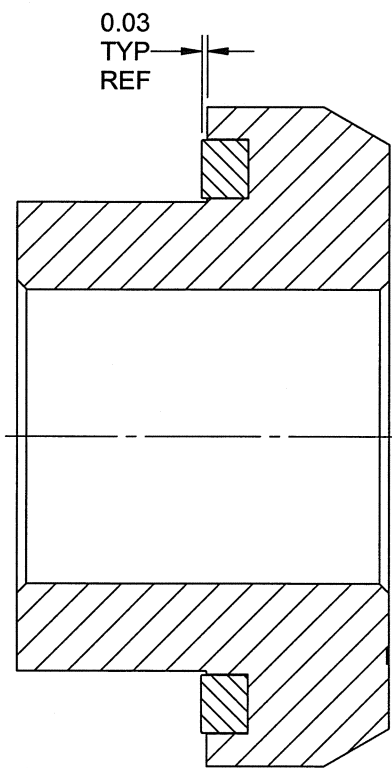
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 5 OF 17
APPROVED	WJ	TITLE	SCALE
DATE 2019-05-24		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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ITEM #	QTY	PART #	PART TITLE
-6	1	RBEM652V3002102-6	BASE
20	6	McMaster#5862K178 OR EQUIV.	NICKEL PLATE NEODYMIUM MAGNET THROUGH THK. 5/16" OD. X 1/4" THK. MAX. PULL 6 LBS

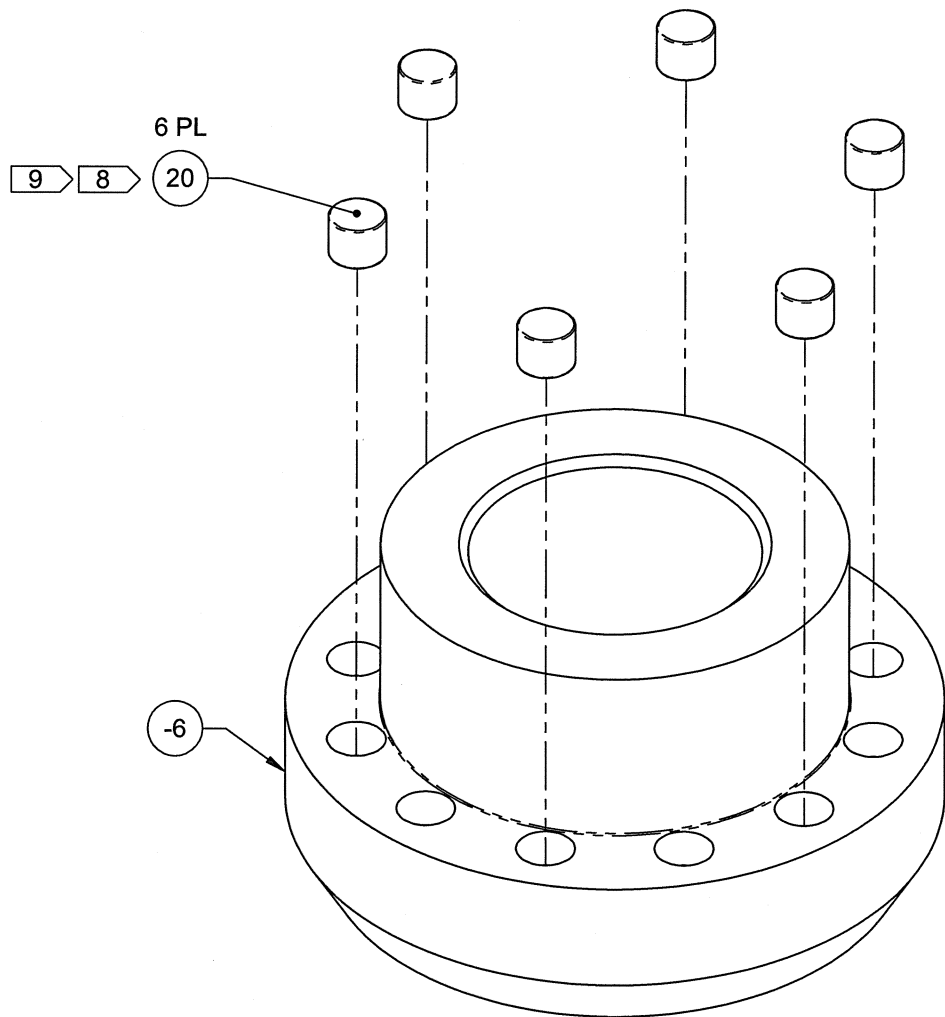


RBEM652V3002102-5 GUIDE ASSEMBLY

10

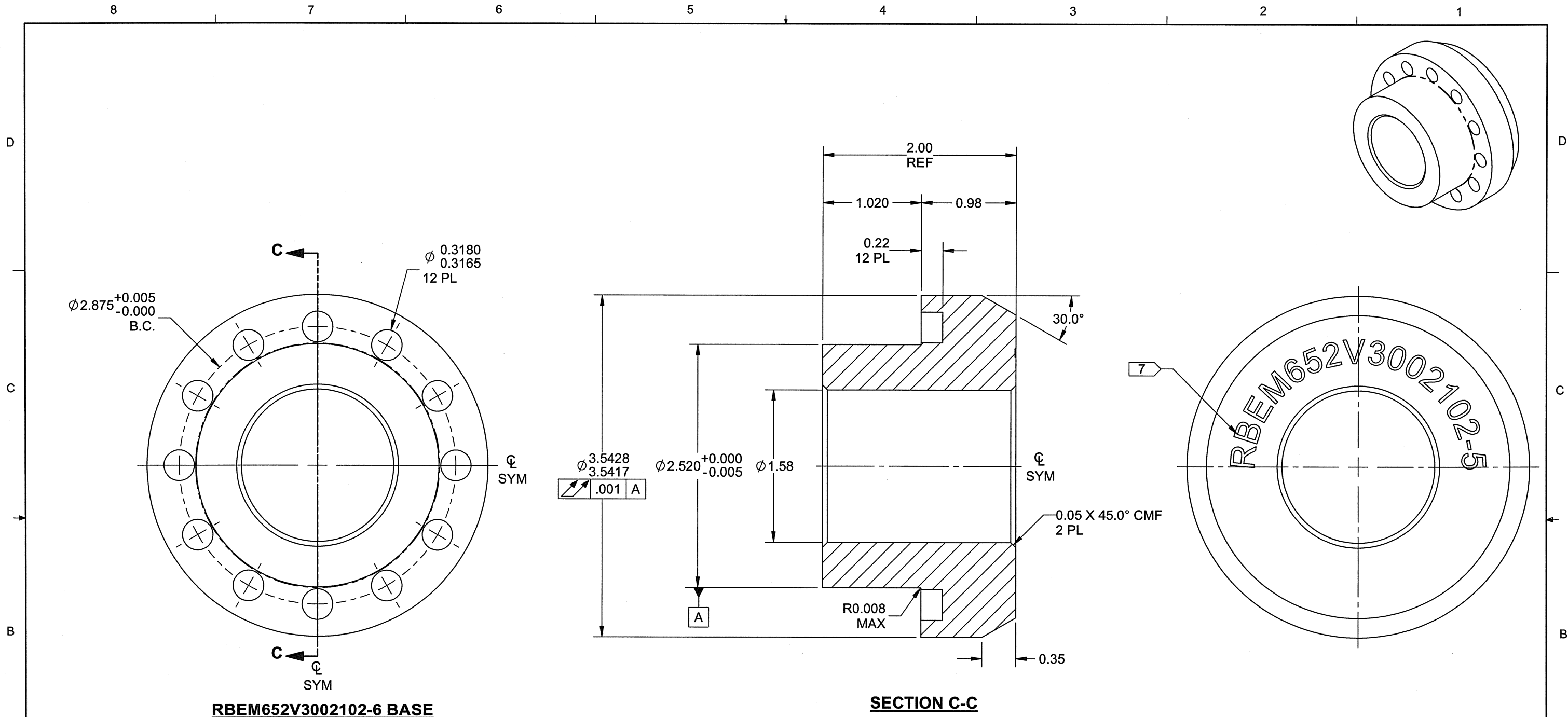


SECTION B-B



- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY INSTANT ADHESIVE LOCTITE 495 BETWEEN THE SURFACES OF ITEM -6 AND ITEM 20, AND REMOVE EXCESS
 - 9) NORTH POLE OF ITEM 20 MUST BE FACING UP AS SHOWN
 - 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 6 OF 17
APPROVED	WJP	TITLE	SCALE
DATE 2019-05-24		TAIL GEAR BOX INPUT SEAL EXCHANGE NTS	NTS
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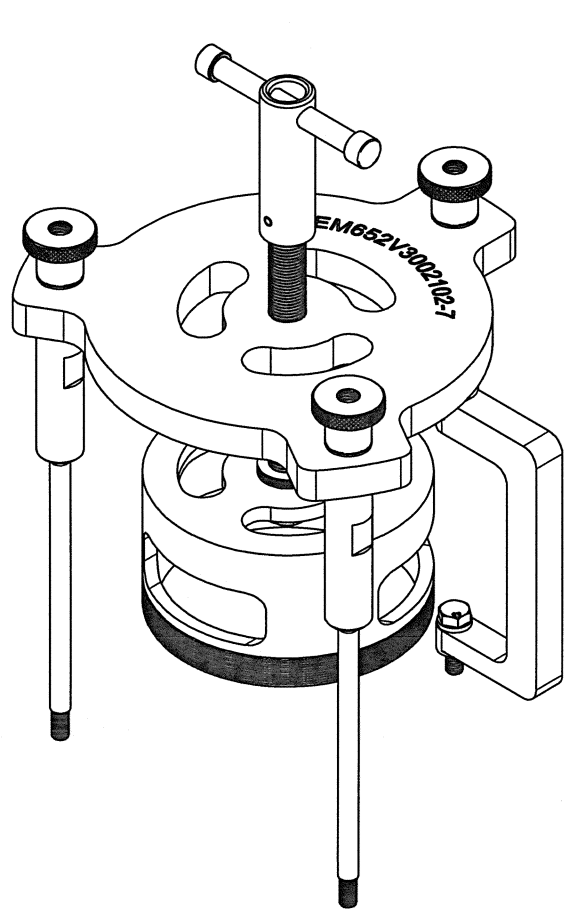


NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK P/N, "RBEM652V3002102-5", AS SHOWN

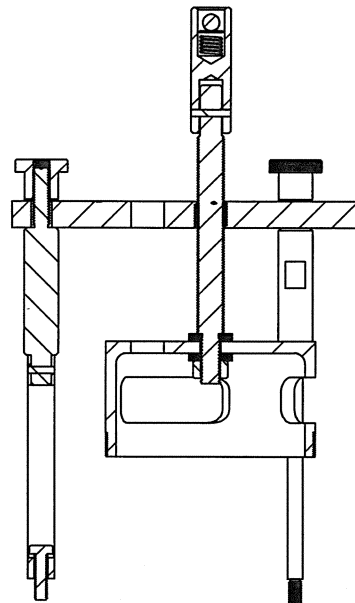
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 7 OF 17
APPROVED	WJ	TITLE	SCALE
DATE 2019-05-24		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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ITEM #	QTY	PART #	PART TITLE
-8	1	RBEM652V3002102-8	GUIDE
-9	2	RBEM652V3002102-9	STUD
-10	1	RBEM652V3002102-10	BAR HANDLE NUT
-11	1	RBEM652V3002102-11	SCREW
-12	1	RBEM652V3002102-12	PLATE ASSY
-14	1	RBEM652V3002102-14	FOOT ASSY
21	1	McMaster#98380A473 OR EQUIV.	416 SS DOWEL PIN 1/8" DIA. X 3/4" LG.
22	1	McMaster#94895A815 OR EQUIV	ZINC YELLOW PLATED GRADE 8 STEEL HEX NUT 3/8"-24
23	3	McMaster#60765K343 OR EQUIV	STEEL ROUND KNOB M8 X 1.25mm THROUGH X 25mm HEAD DIA.
24	3	McMaster#95229A480 OR EQUIV	CAD PLATE STEEL WASHER 5/8" OD X 0.39" ID X 0.029-0.035 THK
25	4	TRA-613	STEEL THRUST WASHER 0.377" ID. X 13/16" OD. X 0.032" THK.
26	2	NTA-613	STEEL NEEDLE ROLLER THRUST BEARING 0.377" ID. X 13/16" OD. X 5/64" THK.

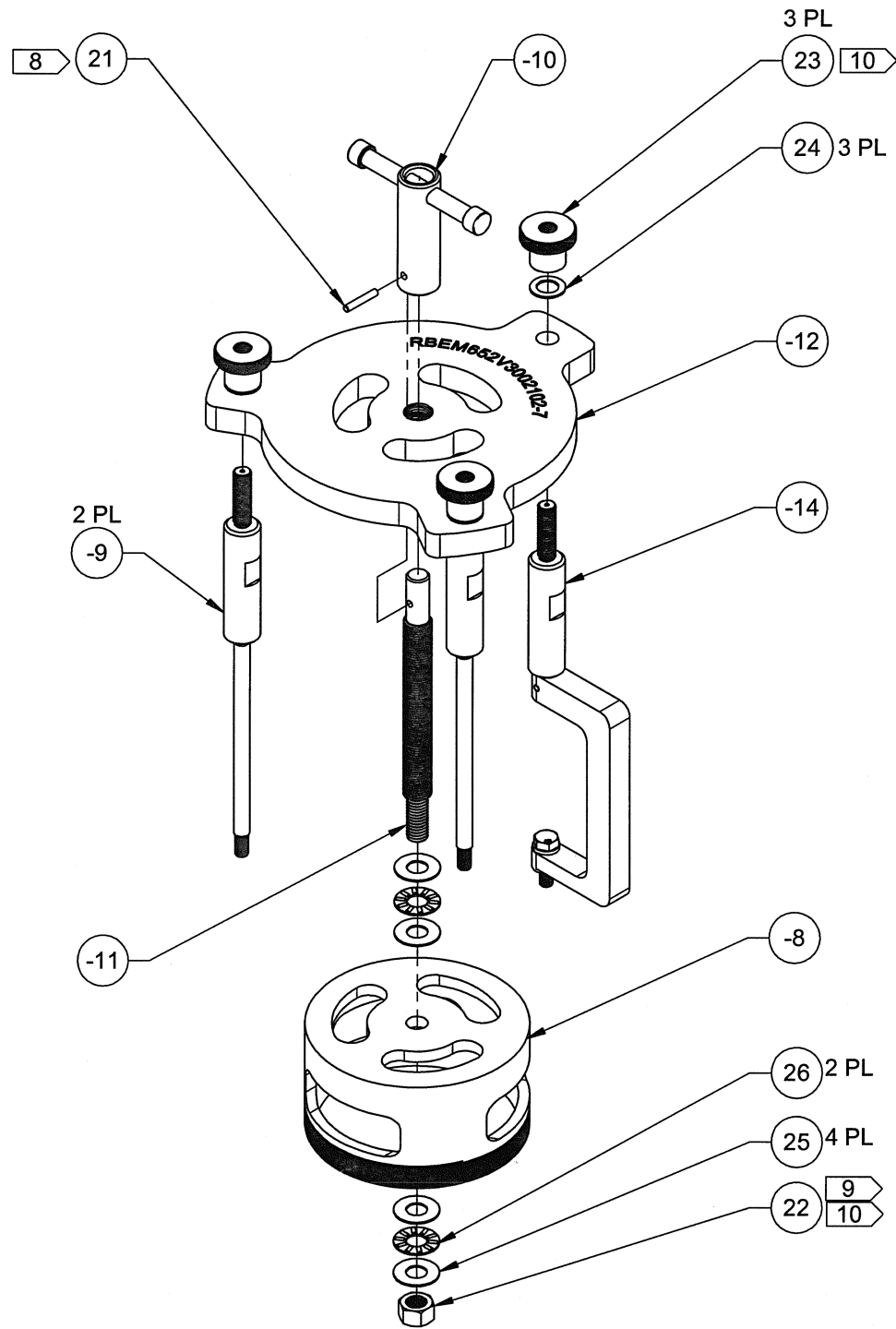
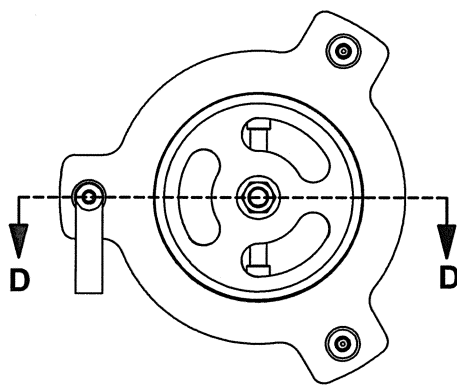


RBEM652V3002102-7 EXCHANGE ASSEMBLY

11

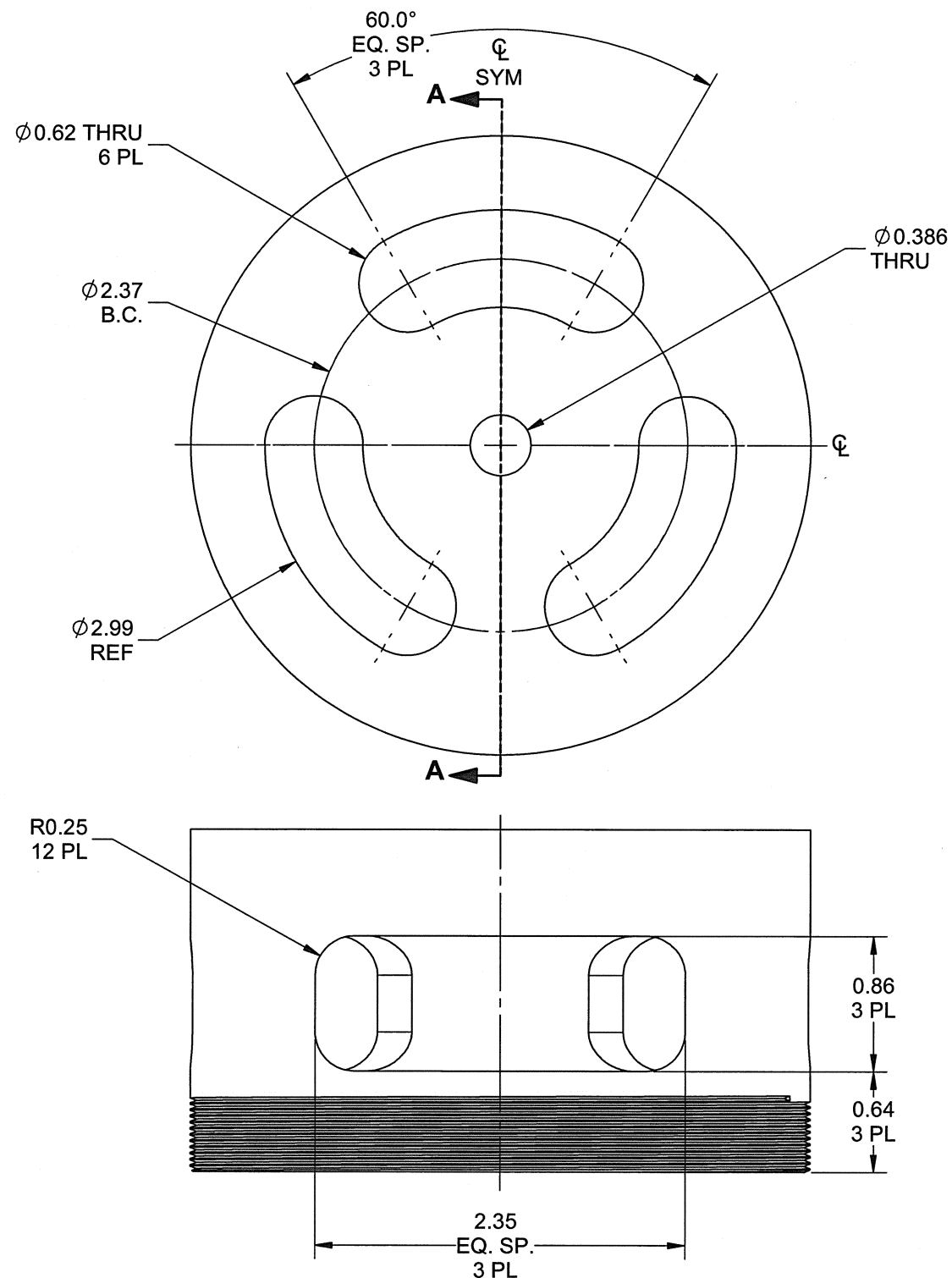
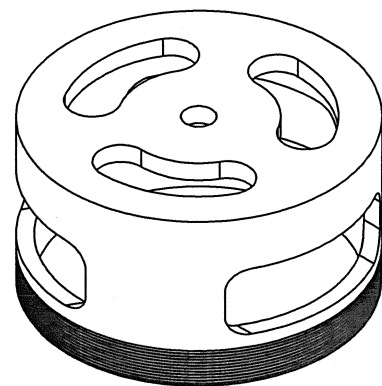


SECTION D-D

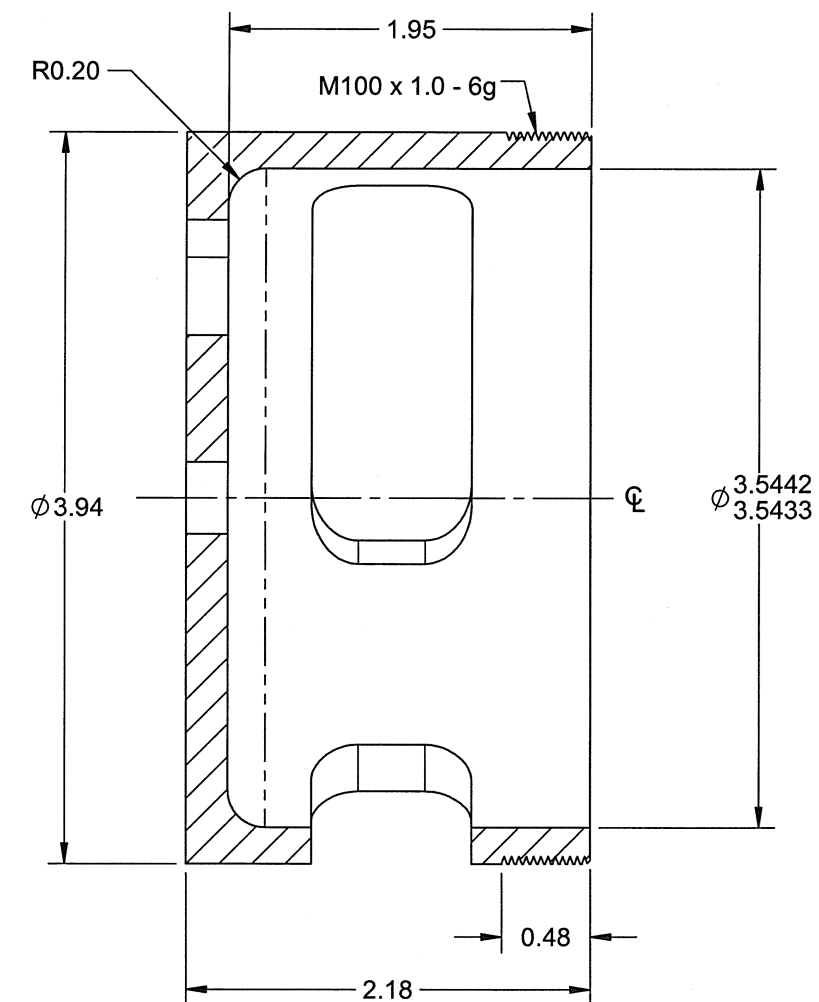


- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 21 WITH ITEM -10 AND ITEM -11 AND REMOVE EXCESS
 - 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 22 THEN ASSEMBLE WITH ITEM -11, AND REMOVE EXCESS
 - 10) ASSEMBLE ITEM 22 AND ITEM 23 HAND TIGHT
 - 11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 8 OF 17
APPROVED	W	TITLE	SCALE
DATE 2019-05-24		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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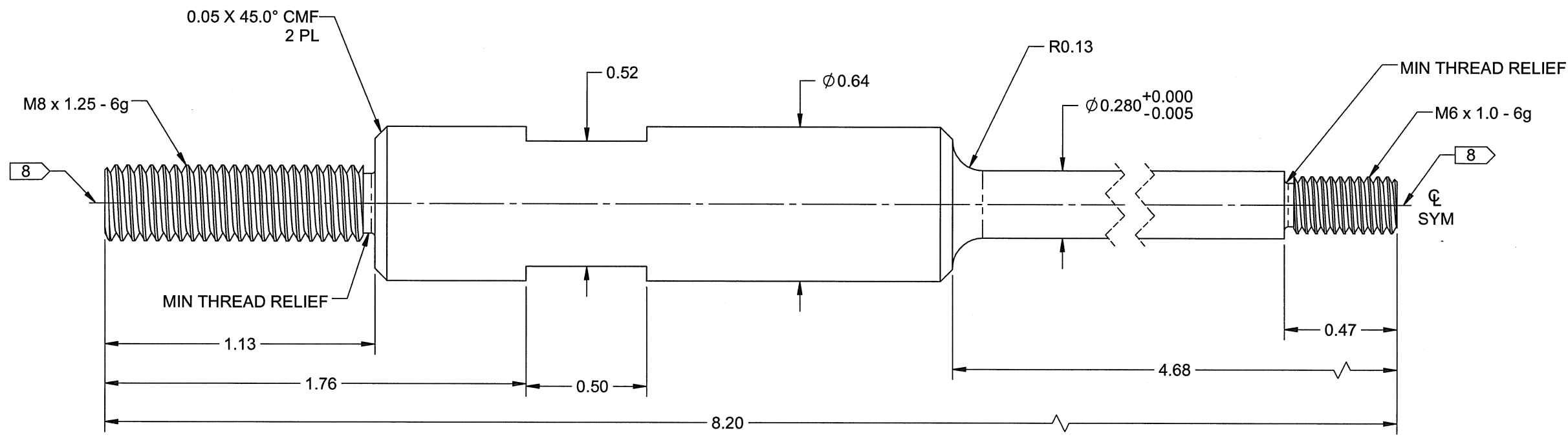
SECTION A-A



NOTES:

- NOTES:**
- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- RBEM6521**

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 9 OF 17
APPROVED	WJ		
DATE 2019-05-24		TITLE TAIL GEAR BOX INPUT SEAL EXCHANGE	SCALE NTS
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RBEM652V3002102-9 STUD

- NOTES:
- 1) MATERIAL: O1
 - 2) HEAT TREAT: 48-52 Rc
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 10 OF 17
APPROVED	VM	TITLE	SCALE
DATE 2019-05-24		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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8

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2

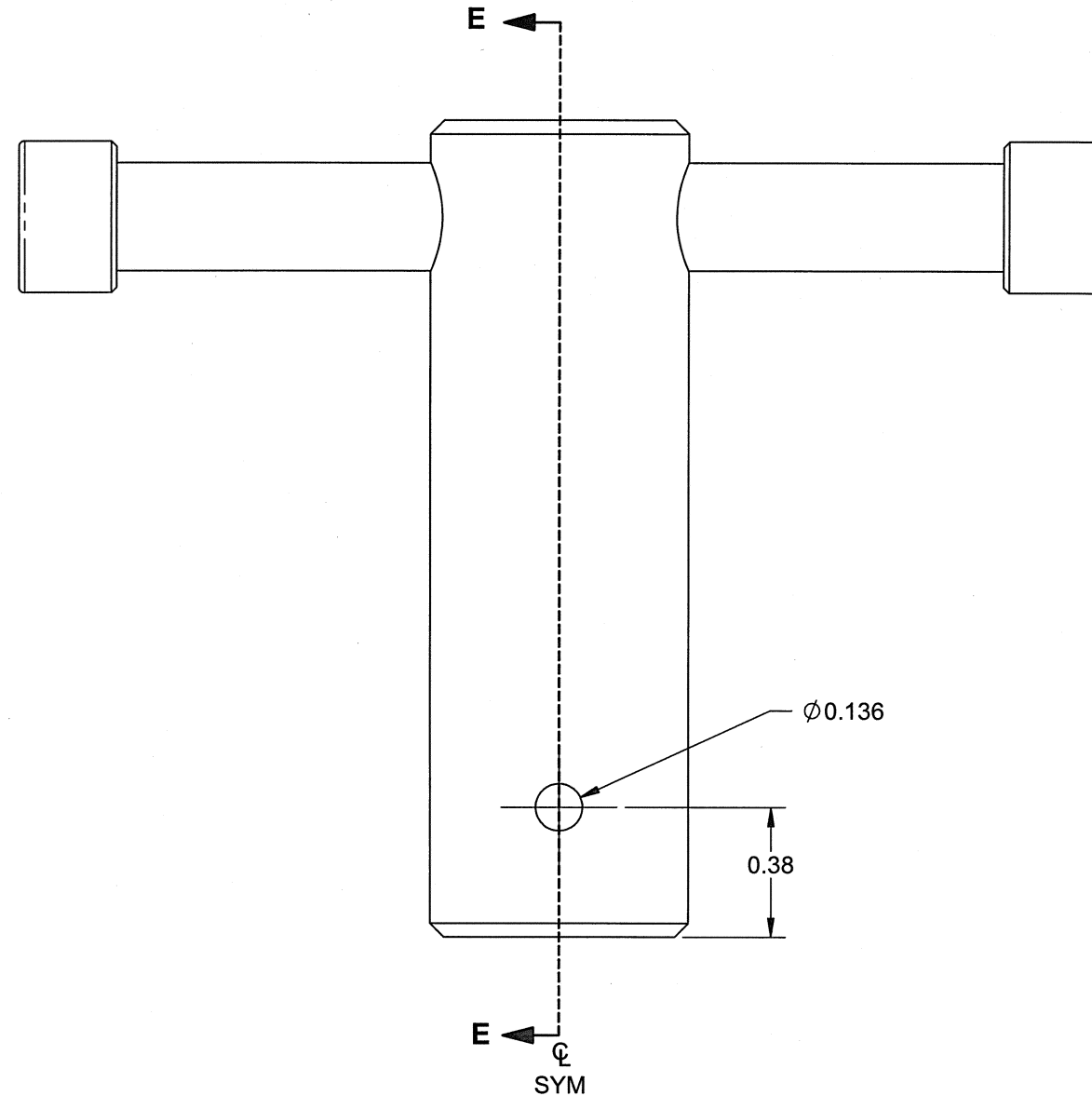
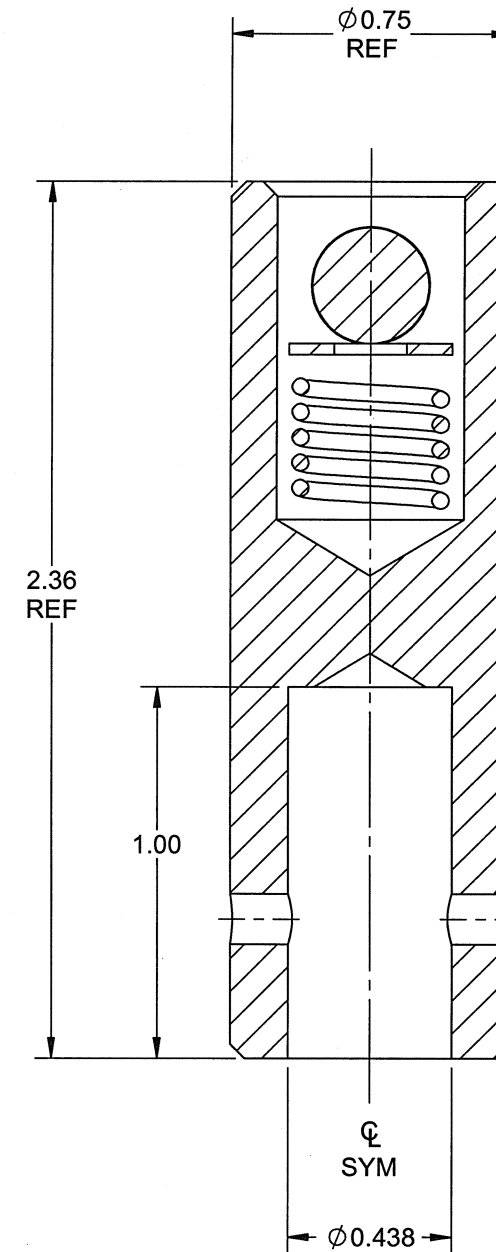
1

D

C

B

A

**RBEM652V3002102-10 BAR HANDLE NUT****SECTION E-E****NOTES:**

1) MATERIAL: CARR-LANE#CLM-10-BHN OR EQUIV. (BAR HANDLE NUT 60 mm OVERALL HT. M10 X 1.5)

2) HEAT TREAT: N/A

3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

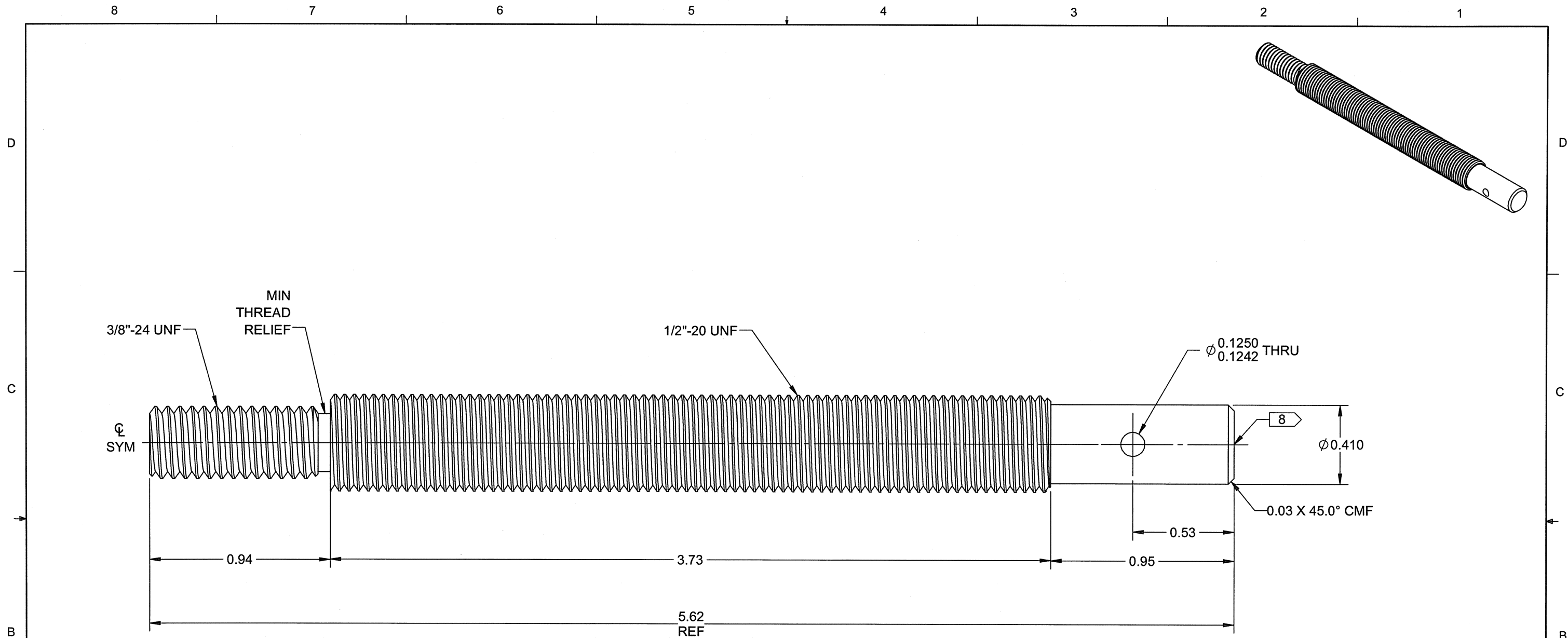
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 11 OF 17
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE 2019-05-24		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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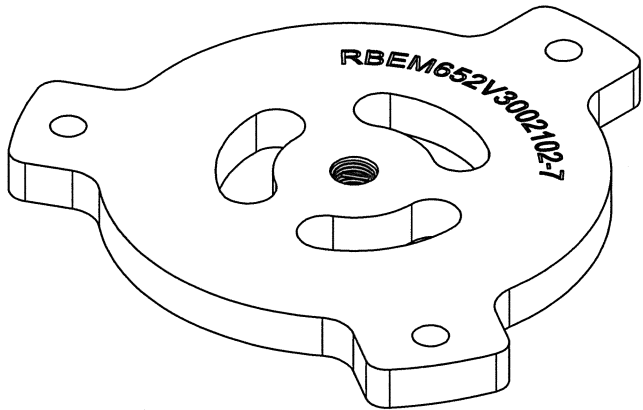
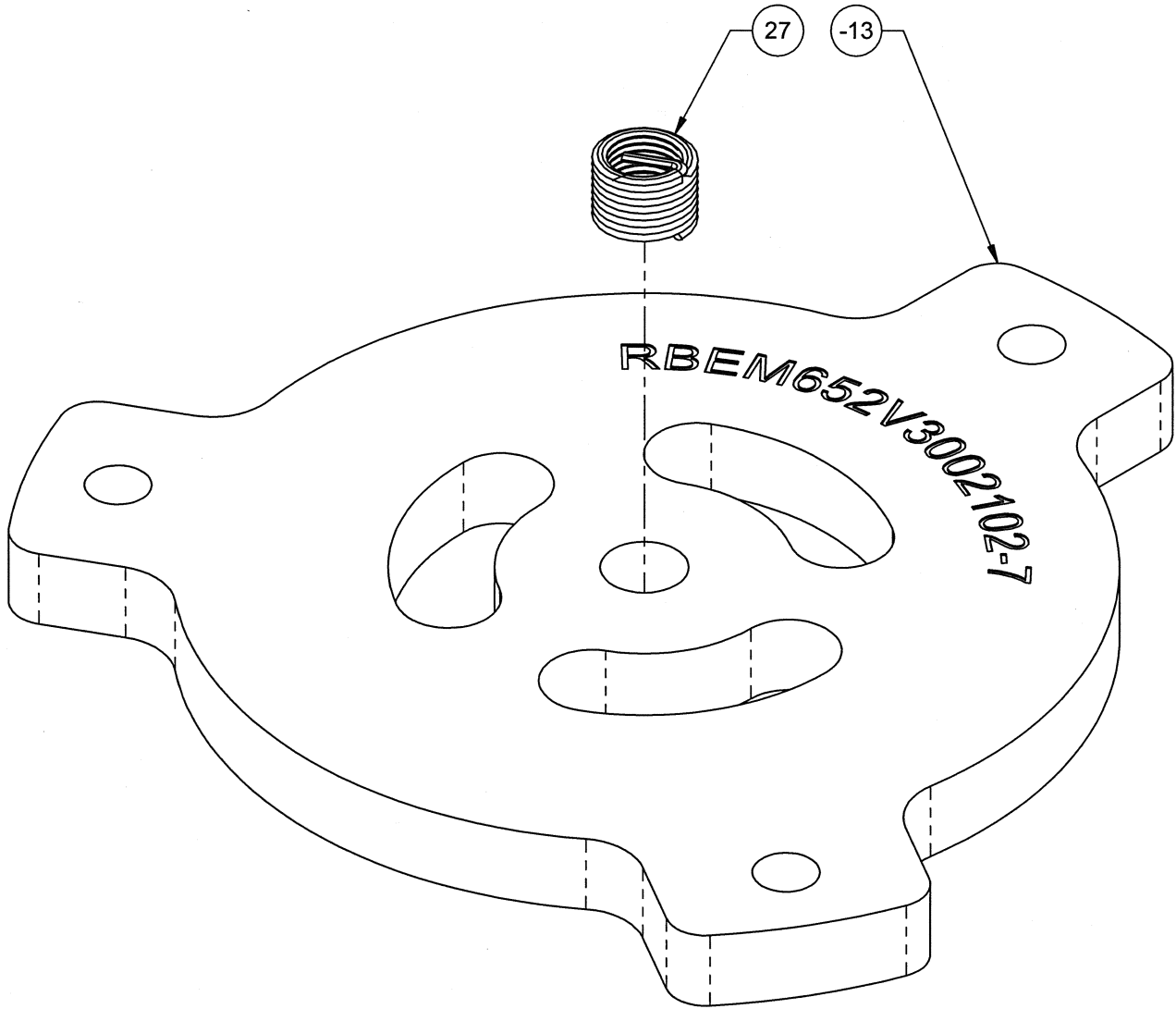


RBEM652V3002102-11 SCREW

NOTES:
1) MATERIAL: 4140 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A
8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 12 OF 17
APPROVED		TITLE	SCALE
DATE 2019-05-24		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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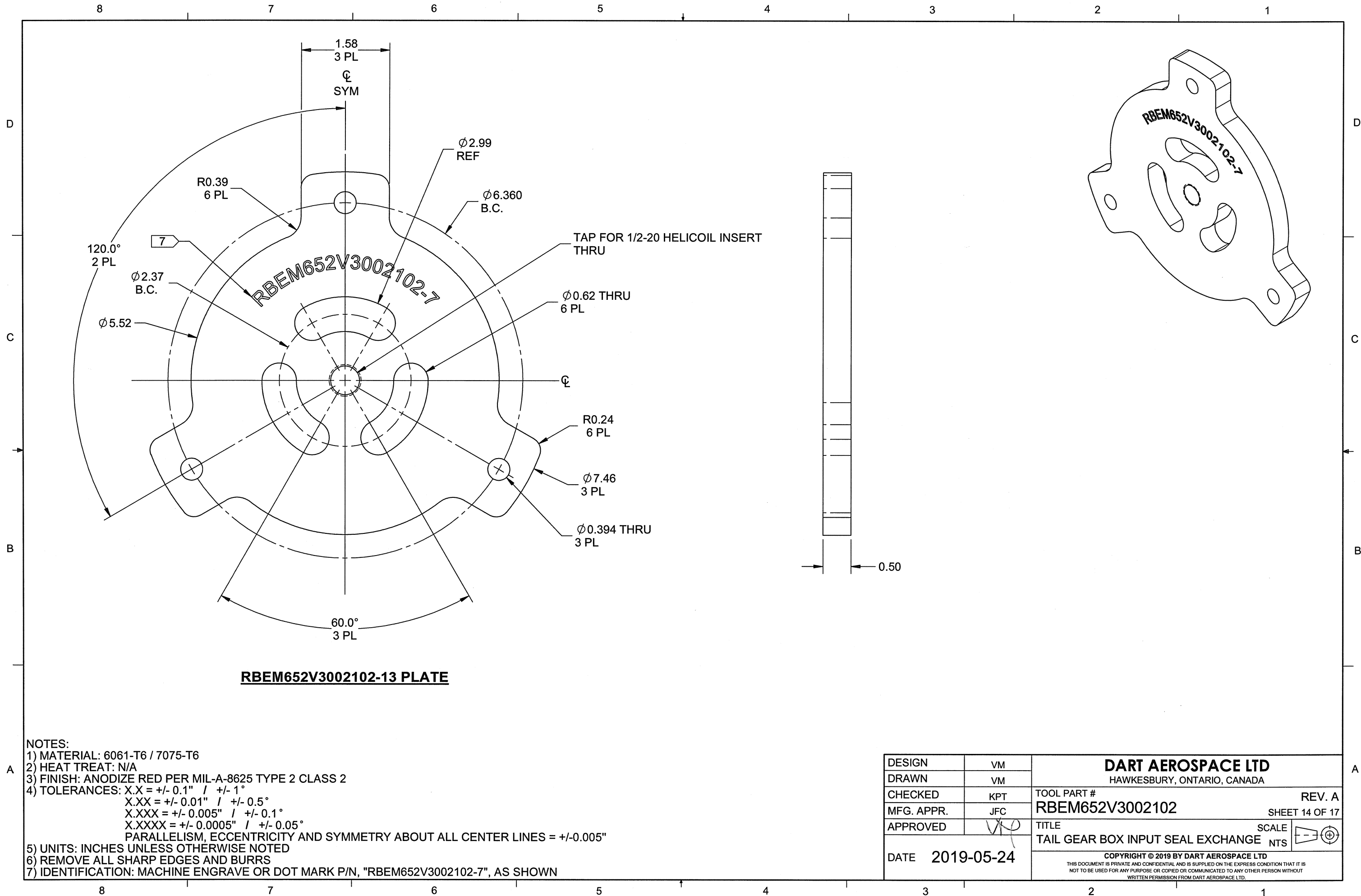
ITEM #	QTY	PART #	PART TITLE
-13	1	RBEM652V3002102-13	PLATE
27	1	McMaster#91732A533 OR EQUIV.	18-8 SS HELICAL INSERT 1/2"-20 X 1/2" LG.



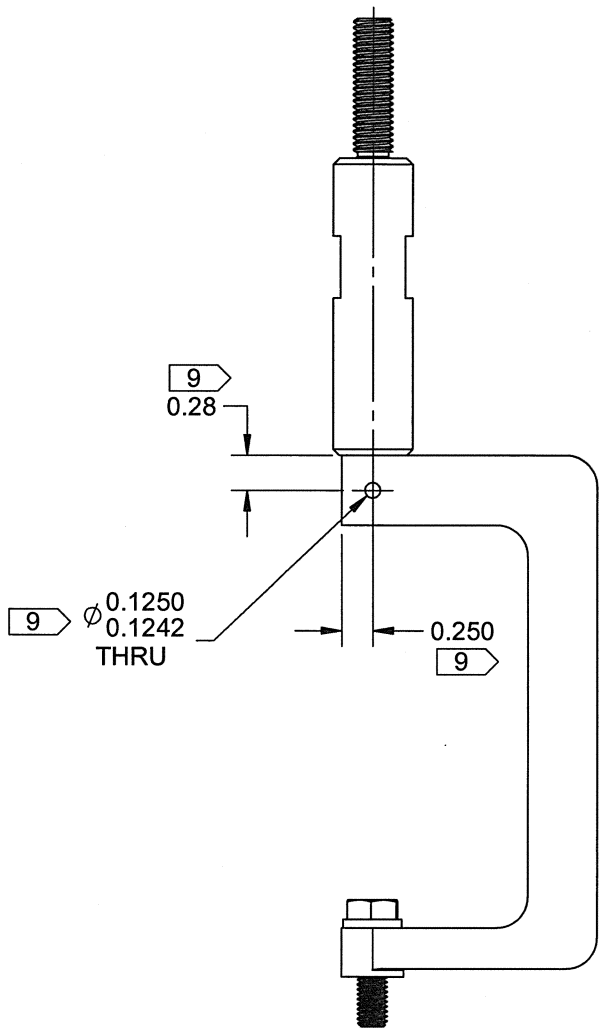
RBEM652V3002102-12 PLATE ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN

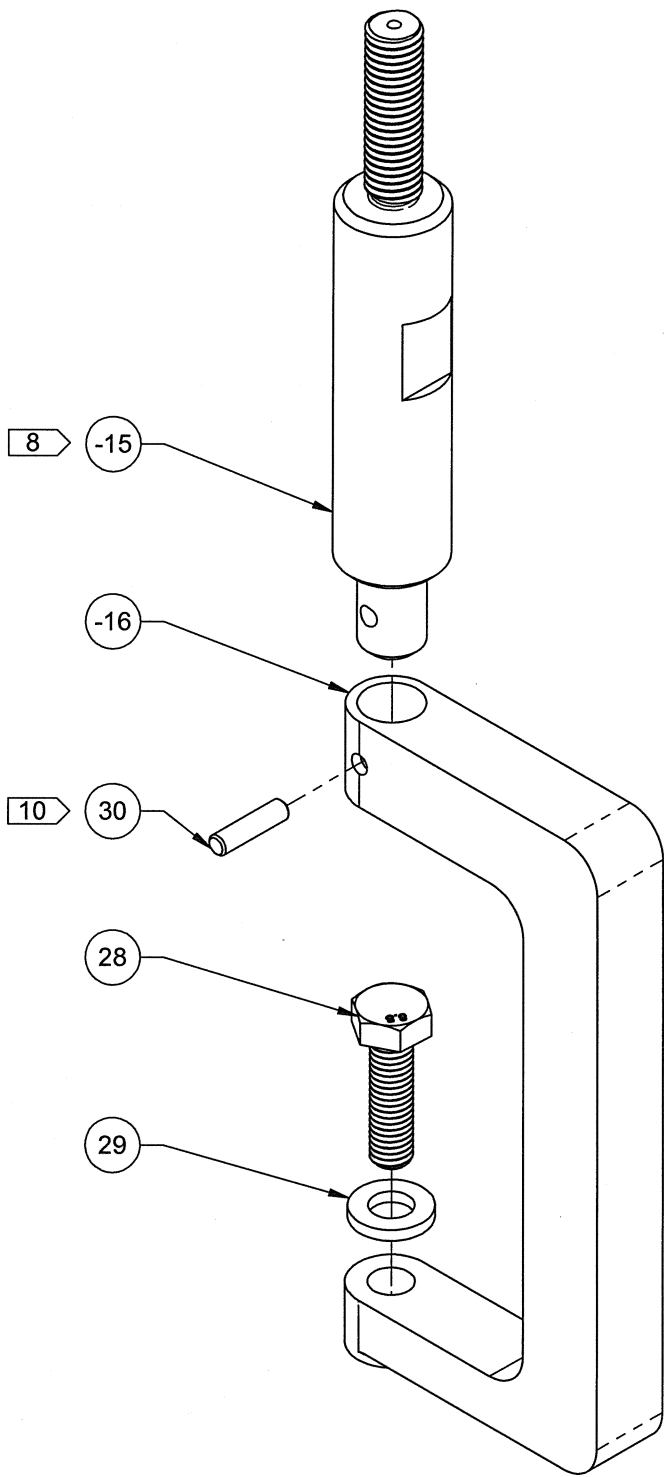
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 13 OF 17
APPROVED		TITLE	SCALE
DATE 2019-05-24		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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ITEM #	QTY	PART #	PART TITLE
-15	1	RBEM652V3002102-15	STUD
-16	1	RBEM652V3002102-16	STUD EXTENSION
28	1	McMaster#91280A332 OR EQUIV.	ZINC PLATE STEEL HEX HEAD BOLT M6 X 1 X 22 mm LG.
29	1	McMaster#91166A250 OR EQUIV.	ZINC PLATE STEEL WASHER 12 mm OD. X 6.4 mm ID. X 1.4 TO 1.8 mm THK.
30	1	McMaster#98381A471 OR EQUIV.	STEEL DOWEL PIN 1/8" DIA. X 1/2" LG.



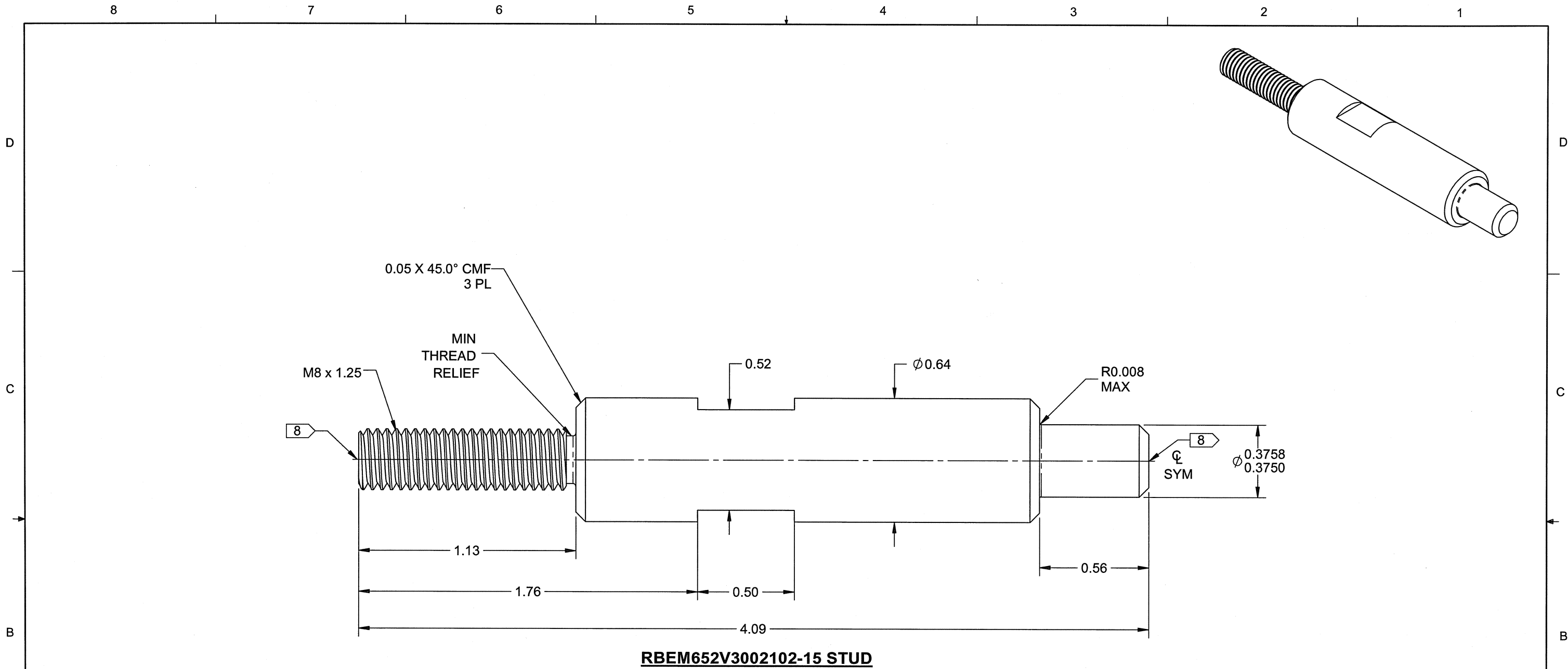
DOWEL PIN REMOVED FOR CLARITY



RBEM652V3002102-14 FOOT ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM -15 WITH ITEM -16, AND REMOVE EXCESS
 - 9) TRANSFER DRILL HOLE THROUGH ITEMS -15 AND -16 AS SHOWN
 - 10) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 30 WITH ITEM -15 AND ITEM -16, AND REMOVE EXCESS

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 15 OF 17
APPROVED	WJP	TITLE	SCALE
DATE 2019-05-24		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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NOTES:

- 1) MATERIAL: O1
- 2) HEAT TREAT: 48-52 Rc
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBEM652V3002102	SHEET 16 OF 17
APPROVED	VM	TITLE	SCALE
DATE 2019-05-24		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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